

Date: Wednesday, 3/26/2008 1:45:13 PM  
User: Kim Johnston

# Process Sheet


Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: REMOVABLE HELI UTILITY STEP RH
Job Number	: 38215		
Estimate Number	: 13195		
P.O. Number	:	Part Number	: D205541048
This Issue	: 3/26/2008 S.O. No. :	Drawing Number	: IIN D205-541 REV G
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: G
Previous Run	: 37725	Material	:
Written By	:	Due Date	: 4/16/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JO 08.3.27</u>		
Comment	: Est Rev:A new issue 08-02-19 verified by: LL Est Rev:B Ecn 1157 08-03-19 DD verified by:		

## Additional Product

Job Number:	
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Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment:	Photocopy bluefile & type labels per PPPD205-541-048	CHG001	<u>08/04/10</u>	<u>08/04/10 JD</u>
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2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment:	PACKAGING RESOURCE #1
Pick Packing Kit	

3.0	D3724042	Step Assy
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Comment:	Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Step Assy	
batch	<u>B 38219</u>

4.0	D37311	PLATE
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Comment:	Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
PLATE	
batch	<u>38434</u>

5.0	D37511	SHIM
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Comment:	Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Shim	
batch	<u>B 38435</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REMOVABLE HELI UTILITY STEP RH

Job Number: 38215

Part Number: D205541048

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN313A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Bolt  
batch M104746

7.0

AN314A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Bolt  
batch M105953

8.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)  
Washer  
batch M106780

9.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)  
Nut  
batch M106825

10.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and pack for shipping as per PPP D205-541-048  
Location: DNAF  
PPP Rev: 08/04/10

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/04/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

...CONTINUED FROM PREVIOUS PAGE

Qty -043	Qty -044	Qty -045	Qty -046	Part Number	Description
2*	2*			MS20600AD4W3	RIVET
2*	2*	2*	2*	MS21042L3	NUT (OR MS21042-3)
4*	4*	5*	5*	MS21042L4	NUT (OR MS21042-4)
16	16	16	16	MS21042L4	NUT (OR MS21042-4)
4*	4*	4*	4*	MS21042L5	NUT (OR MS21042-5)
2	2	2	2	MS21042L5	NUT (OR MS21042-5)

\* = ASSEMBLED AT DART

## 6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

## 7.0 OPTIONAL EQUIPMENT

Qty -049	Part Number	Description
X	D205-541-049	LINER KIT
1	D2446	SIGN PLATE
1	D2509	LINER (BASE)
1	D2511	LINER (END)
6	MS24693S272	SCREW
6	A3235-020-935	WASHER
6	NAS679A3W	NUT
4	MS20470AD4-8	RIVET
42	MS20600AD4W4	RIVET

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Revision: 10  
Date: 08.03.04

